



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2332-041
Job Sheet 211497



Part No: D2332-041

Job Qty: 6 pcs

Part Name: Lid Prop Assembly 6.69"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/17/20

Job Tracking No:

Due Date: 7/30/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF IPP Rev:C 08-06-02 add comment DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Small Fab - 1	6 pcs	7/29/20		0.32	1.88	Small Fab - 1			58 JUL 31 2020 9-89
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
							Small Fab - 8			
							Small Fab - 9			
							Small Fab - Various 1			
110	Small Fab - Brake NC - B4B	6 pcs	7/29/20		0.25	0.68	Small Fab - Brake - 1 - B4B			58 JUL 31 2020 9-89
							Small Fab - Brake - 2 - B4B			
							Small Fab - Brake - 3 - B4B			
120	Small Fab - 2 - B4B	6 pcs	7/29/20		0.00	1.88	Small Fab - 1 - B4B			58 JUL 31 2020 9-89
							Small Fab - 2 - B4B			
							Small Fab - 3 - B4B			
							Small Fab - 4 - B4B			
							Small Fab - 5 - B4B			
							Small Fab - 6 - B4B			
							Small Fab - 7 - B4B			
							Small Fab - 8 - B4B			
							Small Fab - 9 - B4B			
							Small Fab - Various 1 - B4B			
			7/29/20		0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			



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Container No: S291257



Part: D2332-041

Job No: 211497

Serial No/Batch: S291257

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/05/20

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					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL 8-5-20
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
140	Large Fab - Welded Assy-2-B4B	6 pcs	7/29/20	0.00 1.49	Large Fab - 1 - B4B	EL 8-5-20
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
150	QC 9	6 pcs	7/29/20	0.00 0.00	QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	DAS 8-5-20
					QC 9 - 9	43 9-89
160	QC 5	6 pcs	7/29/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	DAS 8-5-20
					QC 5 - 49	43 9-89
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
170	Small Fab - 3 - B4B	6 pcs	7/30/20	0.00 1.88	Small Fab - 1 - B4B	DAS 58 AUG 06 2020
					Small Fab - 2 - B4B	9-89
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Plex 7/17/20 2:09 PM Dart.lajeunesse.marie	

180 QC 5	6 pcs	7/30/20	0.00 0.00	Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
190 Packaging 3-1 - Stock - B4B	6 pcs	7/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

DAS
81
9-89

AUG 07 2020

DAS
28
9-89

AUG 07 2020

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
200 QC 21 - SA	6 pcs	7/30/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 9	21
				QC 21 - SA - 77	9-09

AUG 07 2020

Part Op 100 - (Small Fab) 1- Cut D2332-7 and D2332-5 to length as per dwg D2332. 2- Cut D2332-11 using 1/2" S.S tubing
 Descriptions: 7.735" long. 3- Deburr.

110 - (Punch ends and deburr as per dwg) Punch and form D2332-11 to length as per dwg D2332 using DT8012 (need 2 per ass'y)

120 - (Small Fab) 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no foreign objects inside tube

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Weld per dwg A/R S.S. rod Batch: M137028) Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)

*****ensure nothing is inside of tube before welding***** S.S Rod batch: _____

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Small Fab) 1- Tumble 2- Assemble as per dwg D2332

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

016780

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.250	304 SS Round bar .250	.6000 ft (.1 ea)	100-Small Fab - 1	5291133
M304TR1.000W.049	304 Round Tube 1.00 X .049W	2.5800 ft (.43 ea)	100-Small Fab - 1	5000698
M304TR0.500W.035	304 Round Tube .500 X .035W	7.5000 ft (1.25 ea)	110-Small Fab - Brake NC - B4B	5173858
AN4-4A	Bolt	6 Ea (1 ea)	170-Small Fab - 3 - B4B	5284008
MS21042L4	Nut	6 Ea (1 ea)	170-Small Fab - 3 - B4B	5284008
NAS1149D0416J	Washer	18 Ea (3 ea)	170-Small Fab - 3 - B4B	fm131511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	M304R0.250	1	0	0
	M304TR1.000W.049	3	47	0
110-Small Fab - Brake NC - B4B	M304TR0.500W.035	8	126	0
	AN4-4A	6	104	0
170-Small Fab - 3 - B4B	MS21042L4	6	1,854	0
	NAS1149D0416J	18	1,217	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lid Prop Assembly	5.000Inches ± 0.030	5.030		
			4.970		
2	Lid Prop Assembly	1.250Inches ± 0.010	1.260		
			1.240		
3	Lid Prop Assembly	6.690Inches ± 0.010	6.700		
			6.680		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S291257



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